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D4379-1**Job Sheet 201955****Part No:** D4379-1**Job Qty:** 60 pcs**Part Name:** Wearplate Cup**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/17/19**Job Tracking No:****Due Date:** 11/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP**Note:** DWG REV D SHEET 1 IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	60 pcs	11/18/19	11/18/19	1.00	7.66	Doosan - 1		19/11/04 JRM
120	QC 8	60 pcs	11/18/19	11/18/19	0.00	0.00	QC 8 - 12		cmk 19/11/04
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	60 pcs	11/18/19	11/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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DAS
65
9-89

				Packaging 3 - 4 - B4B						
				Packaging 3 - 5 - B4B						
				Packaging 3 - 6 - B4B						
				Packaging 3 - 7 - B4B						
				Packaging 3 - 8 - B4B						
				Packaging 3 - 9 - B4B						
				Packaging 3 - 10 - B4B						
				Packaging 3 - 11 - B4B						
				Packaging 3 - 12 - B4B						
				Packaging 3 - 13 - B4B						
				Packaging 3 - 14 - B4B						
				Packaging 3 - 15 - B4B						
				Packaging 3 - 16 - B4B						
				Packaging 3 - 17 - B4B						
				Packaging 3 - 18 - B4B						
				Packaging 3 - 19 - B4B						
				Packaging 3 - 20 - B4B						
				Packaging 3 - 21 - B4B						
				Packaging 3 - 22 - B4B						
				Packaging 3 - 23 - B4B						
				Packaging 3 - 24 - B4B						
				Packaging 3 - 25 - B4B						
				Packaging 3 - 26 - B4B						
				Packaging 3 - 27 - B4B						
				Packaging 3 - 28 - B4B						
				Packaging 3 - 29 - B4B						
				Packaging 3 - 30 - B4B						
				Packaging 3 - 31 - B4B						
				Packaging 3 - 32 - B4B						
				Packaging 3 - 33 - B4B						
				Packaging 3 - 34 - B4B						
				Packaging 3 - 35 - B4B						
				Packaging 3 - 36 - B4B						
				140	QC 21 - SA	60 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	DAS
									QC 21 - SA - 70	21
									QC 21 - SA - 53	9-30 NOV 0 5 2019

Part Op 100 - (Doosan Lathe) turn as per Dwg and folio FB057
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: WA001) LOCATION: WA001-15
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	3 ft (.05 ea)	100-Doosan - 1	\$200 820

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R0.750	3	25	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
2	Wearplate	0.507Inches ± 0.010	0.517 0.497		
3	Wearplate	0.233Inches ± 0.010	0.243 0.223		
4	Wearplate	0.466Inches ± 0.010	0.476 0.456		
5	Wearplate	0.625Inches + 0.000 - 0.005	0.625 0.620		
6	Wearplate	0.200Inches ± 0.010	0.210 0.190		
7	Wearplate	0.438Inches ± 0.010	0.448 0.428		
8	Wearplate	0.030Inches ± 0.100	0.130 (0.070)		
9	Wearplate	45.000Degrees ± 0.000	45.000 45.000	Angle	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS				MRRB (QS1042)																																																																									
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition		Completed By																																																																									
Description Work Order Deviation								Lead hand / Supervisor																																																																									
								QC / QA Coordinator																																																																									
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td></td><td>Contamination</td><td></td><td>Power Loss/Surge</td><td></td><td>Positioned Wrong</td><td></td></tr><tr><td>Bending</td><td></td><td>Misaligned/off center</td><td></td><td>Folio/Program</td><td></td><td>Outside Tolerance</td><td></td></tr><tr><td>Crushing</td><td></td><td>BOM/Route</td><td></td><td>Grain Direction</td><td></td><td>Drawing</td><td></td></tr><tr><td>Cracks</td><td></td><td>Broken/Damage/Defect</td><td></td><td>Weld</td><td></td><td>Finish</td><td></td></tr><tr><td>Crimp/kink/Ripple/Wave/Twist</td><td></td><td>Incomplete/Unclear Instructions</td><td></td><td>Wrong Stock Pulled</td><td></td><td>Part Lost/Missing</td><td></td></tr><tr><td>Marks/Chatter</td><td></td><td>Drill Holes</td><td></td><td>Out of Sequence</td><td></td><td>Misread</td><td></td></tr><tr><td>Mislabeled</td><td></td><td>Fit/Function</td><td></td><td>Off-set/Set-up</td><td></td><td></td><td></td></tr></table> Other/Details: _____								Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong		Bending		Misaligned/off center		Folio/Program		Outside Tolerance		Crushing		BOM/Route		Grain Direction		Drawing		Cracks		Broken/Damage/Defect		Weld		Finish		Crimp/kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing		Marks/Chatter		Drill Holes		Out of Sequence		Misread		Mislabeled		Fit/Function		Off-set/Set-up			
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